

Work Order ID 165528

Friday, August 25, 2017 11:36:19 AM

165528

SHIP 14/SEPT

Page 1

Item ID: D3171-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angle Bracket

Start Date: 8/25/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/30/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

AUG 25 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3171

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.44

FLOW CNC Waterjet

1-Cut as per Dwg D3171

Dwg Rev: BProg Rev: B

2-Deburr if necessary

(12)

0217/08/26

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.12

Quality Control

(12)

0217/08/26

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Item ID: D3171-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Angle Bracket
Start Date: 8/25/2017 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 8/30/2017 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Sto19</u>	0.00							
160									
Packaging	Memo	0.12				12		SEP 01 2017	DAS 6 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.20						SEP 01 2017	DAS 21 9-89
Quality Control									

DAS
21
9-89 SEP 01 2017

Picklist Print

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Work Order ID: 165528

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Parent Item: D3171-1

D3171-1

Parent Item Name: Angle Bracket

Start Date: 8/25/2017

Required Date: 8/30/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A02.11.04New IssueKJ
IPP Rev:B 08-03-27 now on water jet DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	122.0000	0.0206	0.260211			

M304S16GA

304/316 Sheet .063

08/17/08/26

Location

Loc Qty

Loc Code

MAT010

122

m138109

0.5

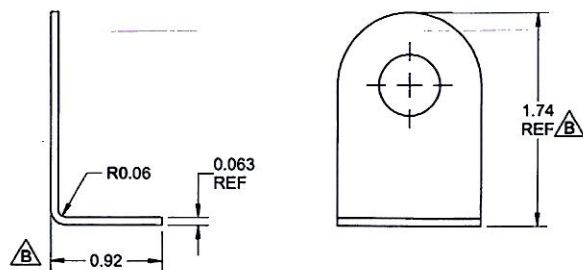
m138175

57.5

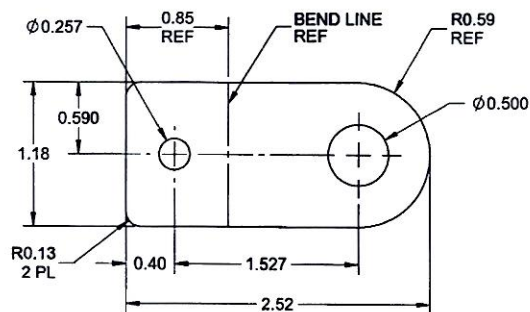
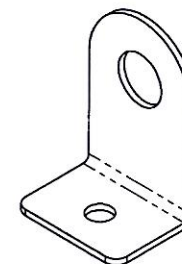
m138346

64

.3



D3171-1 ANGLE
(MAKE FROM D3171-1F)



D3171-1F
FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165528MUS
1-7-08-25

D3171-1/-1F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, ANNEALED, 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

RELEASED
2016-11-09
8216-668

APPROVED

B	UPDATE TO CURRENT STANDARD; D3171-1: 0.92 AND 1.74 REF WERE 0.90 REF AND 1.72 (MFG REQUEST/CAD ERROR); ADD D3171-3. REASON: PAR14-380.	MB	16.07.14
A	NEW ISSUE	DS	02.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D3171	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	ANGLE	NTS
DATE	16.07.14	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	